5145

SPLIT 0

DART AEROSPACE LTD.	Work Order:	24433
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
Drawing: D2571 Rev. D/D2572 Rev. D	Qty:	8
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	KI	05,10,12	8
		Dwg not required	10	03,10,12	0
2	MV	Make from D6101-007 billet for D2571			
		Ensure that grain is along 7.75" length	50	oslialas	8
3	MV	Make from D6101-005 billet for D2572	70	02119192	U
3	IVIV	Ensure that grain is along 5.00" length			
		Batch No: B21817-A	5.6	05/12/23	8
4/	MV/	Fixturing W/O Nø.			1 1
/	/	Fixturing Inspection last completed / by		MAIA	
5	MV	Program Batch No. 24433	-1		CI
		Double check by:	J.L	05-12-28	8
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached	M8/	. v	722
	104	Dimension Sheets	1	06/01/03	8
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	m8/		J.
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached	DL	06/01/03	
O	IVIV	Dimension Sheets	18/	06/01/03	8
9	MV	Machine keyway as per dwg D2571 & D2572	1		
			MSA	06/01/03	8
10	MV	Deburr and remove all machining marks	MSIL	10 W	Des.
			-	Odolc3	8
11	MV	Tumble for 20 minutes to semove shap edges of 04.06.21	M8/	1 1	8
10	001	R M	DI	celorlos	D
12	QC1	Inspect all dimensions to dimension sheets	MASI	06/01/03	安子
13	QC7	Second inspection	-OL	00/01/03	0 /
13	QC/	Second inspection	200	06/01/0	5 7
14	FP	Acid etch and alodine as per QSI 005 4.1	~	09/01/0	7/
Mests	200		71	06/01/11	1/5
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	1		7/
			m	06 01 16	15
16	QC3	Inspect Powder Coat	1	11	-/
		(	20	6/1/17	1/5
17	ST	Identify and Stock.		11	1
18	AC	Luc 372	0	16/1/17	45
10	AC	Cost / Part	Sue-	do-01-18	
19	DC	Close W/O	-	4-01-18	
		Inspection Level 21	13	06/01/18	

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	1
Н	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	-0/
1	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ TRF	<b>V</b>



中 05.07.07

7	-
-	-

W/O:		WORK ORDER CHANGES								
DATE	STEP	TEP PROCEDURE CHANGE By			Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector		
THE W						جلوا		H		
								[1]		

NCR:		w	ORK OR	DER NON-CONFORMANCE	(NCR)			
	0755	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Design Mgr	QC Inspector
adolog	٩	- New tool to cot groove, tool wasn't sharpened to the right dimension, I saddle 2571 affected	A CHILL	Scraps. destrat replace tool with paper size, Destrujorisinal tool	06/01/09	06.01.05	A PART	160108
Odcilos	٩	- new tool to cut groove, tool wasn't sharpened to the right dimension, I saddle 2572 affected	orano	Scrapi des traj  Replace tool with  Areper size. Destrajoriginal  tool	MB cololog	06.01.01	OF THE	06-01-08

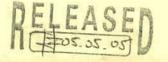
Part No: Dasni lassa	PAR #:	Fault Category:	NCR:	Yes No DQA:	Date: 06/01/18
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

DART AEROSPACE LTD	Work Order:	24433
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. D		Page 1 of 1

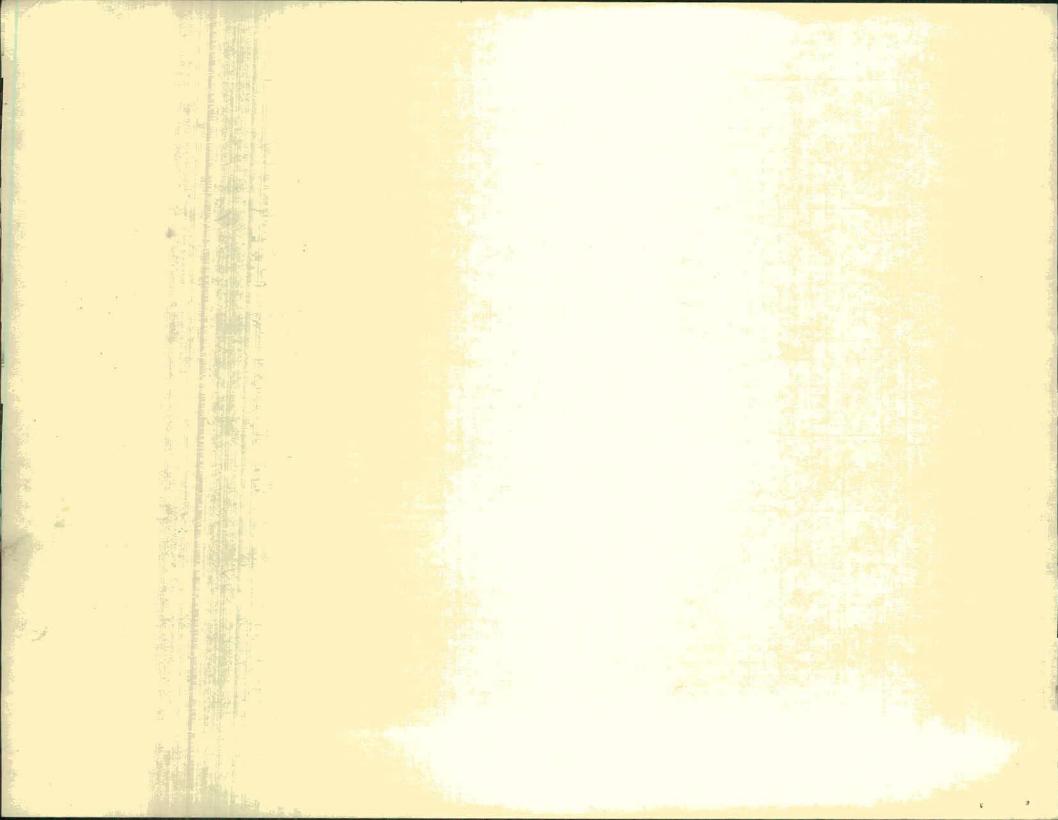
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. D and record below:

				Re	Recorded Actual Dimensions				-
Dim	Min	Max	Go/No Go Gauge	1/	2	3	4	Ву	Date
Α	0.438	0.443	DT8682		1				
В	1.745	1.755		1.750	1.749	1,750	1.752		
С	3.495	3.505		3.500	3.500	3.501	3.504		
D	1.745	1.755		1.750	1.749	1.750	1.750		
E	7,990	8.010		8.002	8.000	8.010	8000		
F	0.490	0.510		,501	.800	.507	,500		
G	0.257	0.262	DT8683	1	11		1		
Н	0.375	0.380	DT8684			~	1		
1	0.490	0.510		.500	. 499	.498	.497		
J	1.174	1.184		1180	1.179	1.179	1.180		
K	0.558	0.578		-568	.566	,565	-569		
L	1.174	1.184		1.179	1.179	1.179	1.180		
M	1.490	1.500		1.495	1-495	1.494	1,495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
0	3.869	3.879		3-874	3-874	3.875	3.872		
P	0.115	0.135		.128	128	-126	.126		
Q	0.115	0.135		135	.135	135	.135		
R	0.240	0.260		-254	-253	.249	-255	<del>                                     </del>	
S	0.115	0.135		-126	-128	130	.132		
T	0.178	0.198		.188.	188	188	188	1 10	
U	2.940	2.980		2.961	2.96	2.962	2.962		
V	0.230	0.250		,240	- 241	-247	348		
W	0.115	0.135		-118	125	125	.127		
X	0.308	0.313		, 312	312	-315			
Y	0.760	0.765		-760	.760		.315		
Z	0.352	0.372		362	362	-160	000		
AA	0.470	0.530		.500	- 500	.365	.364 500		
AB	0.615	0.635		-627	-627		.500		
AC	0.053	0.073		063		.629	.628		
AD	0.240	0.260		-251	-250	.063	.063		
AE	1.375	1.395		1387	1.388	00)60	.252		
AF	0.115	0.135		135	-135	1386	1.387		
AG	0.240	0.280		-260	-1-23		-135		
AH	0.240	0.260		.255	-252	,260	260		
AI	2.000	2.020		2.001	2.002	254	245		
		ept/Rejec	ct	Reject	Q.000	5.005	2.001		
AJ	1.023	643		N/A	.030	050	45 A		-
	asured by			1 ////		udited by	5030		
,,,,		: 05-12	000		A	Date:	261-11	0	
	Date	. 03-10	C-01. X			Date.	06/0//	07	

Rev Date Change Revised by Approved New Issue A RF В 02.09.24 Re-format; Added Rev. D KJ C 02.10.11 Re-format; Added DT8682, DT8683, DT8684 KJ D 05.05.05 Added dimension Al KJ/RF





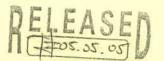


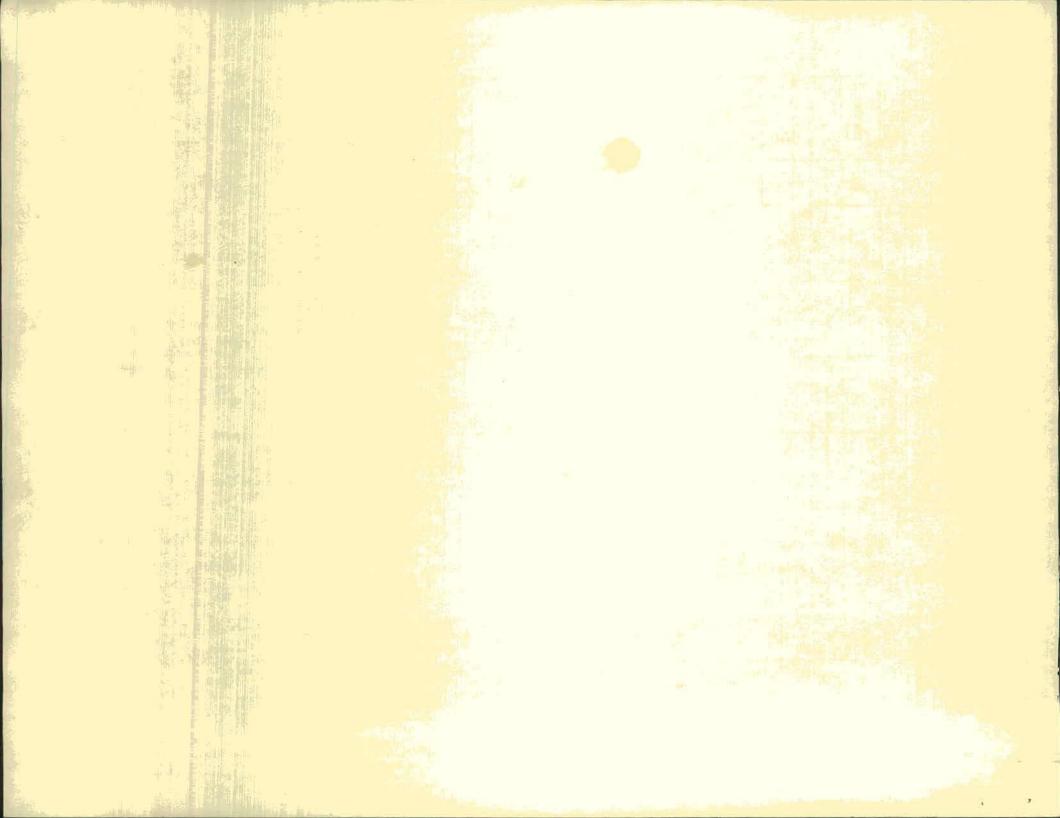
DART AEROSPACE LTD	Work Order:	24433
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682	~	/		-		
В	1.745	1.755		1.751	1.751	1.752	1.751		
C	3.495	3.505		3.500		3,500	3.501		
D	1.745	1.755		1.151	1.751		1.751		
E	7.990	8.010		8.002		8.002	8.004		
F	0.490	0.510		. 499	498	.499	499		
G	0.257	0.262	DT8683	~					
Н	0.375	0.380	DT8684	~	V	V	V		
1	0.490	0.510		-504	.503	.500	.500		
J	1.174	1.184		1.180	1.179	1.179	1.179		
K	0.558	0.578		,545	-569	.512	.570		
L	1.174	1.184		1.180	1.180	1.179	0.180		
М	1.490	1.500		1.496	1.493	1,494	1,494		
N	2.495	2.505		2.501	2.500	2.500	2.499		
0	3.869	3.879		3 812	3871	3812			
Р	0.115	0.135		127	3510	.128	.129		
Q	0.115	0.135		.128	135	-132	-130		
R	0.240	0.260		249	.248	,255	-257		
S	0.115	0.135		.129	,127	138	.127		
T	0.178	0.198		188	.156	381.	.188		
Ü	2.940	2.980		2.961	2.962	2.964	2.962		
V	0.230	0.250		,241	244	-244	245		
W	0.115	0.135		,128	,130	.130	-127		
X	0.308	0.313		.311	311	.311	.31		
Y	0.760	0.765		.762	.7602	-762	507.		
Z	0.352	0.372		.362	362	362	.363		
AA	0.470	0.530		,500	,500	.500	. 500		
AB	0.615	0.635		628	.628	.628	.628		
AC	0.053	0.073		.063	· CC63	.063	.063		
AD	0.240	0.260		249	.250	250	.250		
AE	1.375	1.395				1.384	1.385		
AF	0.115	0.135		2134	,135	.135	.130		
AG	0.240	0.280		270	. 269	, 258			
AH	0.240	0.260		249	250	.253	, 242 , 254		
Al	2.000	2.020		2.000	2.000	2.000	2.000		
		ept/Rejec	et	2.000	~	2.000	a.cc		
A J		0.043		-C3C	. 630	1 .0000	250		
		: Me		al X	Δ	udited by	CO	1	
		: 06					06/01/0	0	

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	-
D	05.05.05	Added dimension AI	KJ/RF	5



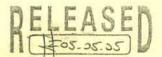


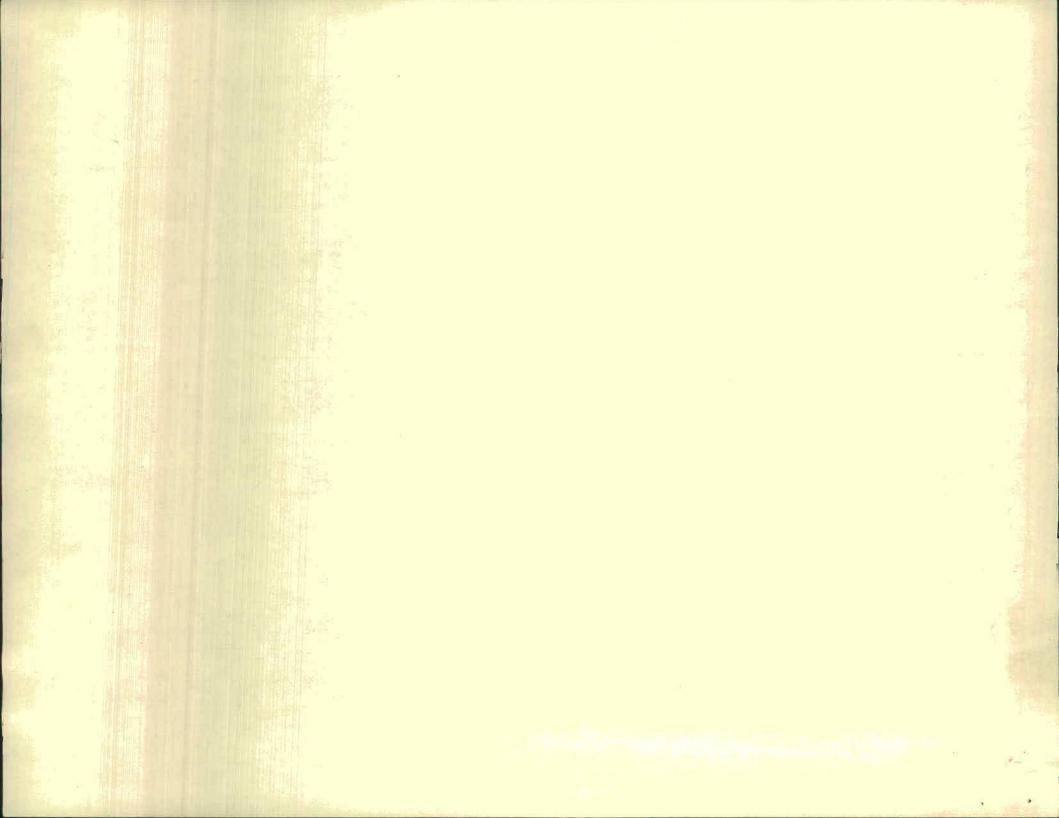
DART AEROSPACE LTD	Work Order:	24433
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. D and record below:

				Re	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
А	0.438	0.443	DT8682			~			
В	1.745	1.755		1.750	1.750	1.750	1.751		
С	3.495	3.505		3.500	3.500	3.500	3.503		
D	1.745	1.755		1.750	1.749	1.750	1.751		
E	7.990	8.010		8.001	7.998	7.991	8,005		
F	0.490	0.510		.500	.498	.498	. 500		
G	0.257	0.262	DT8683	1	11		V		
Н	0.375	0.380	DT8684						
_1	0.490	0.510		- 500	.498	.497	499		
J	1.174	1.184		1.179	1.179	1.181	1,180		
K	0.558	0.578		-568	565	.569	,568		
L	1.174	1.184		1.180	1.179	1.179	1.180		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2501	2.502	2.500		
0	3.869	3.879		3.874	3.874	3.873	3.872		
P	0.115	0.135		126	125	-126	-126		
Q	0.115	0.135		-135	-135	-135	.135		
R	0.240	0.260		-252	253	250	.256		
S	0.115	0.135		124	,124	127	.120		
Т	0.178	0.198		-188	188	198	178	- 1	
U	2.940	2.980		2961	2.962	2962	2.964	1	
V	0.230	0.250		- 240	237	.241	. 239		
W	0.115	0.135		.130	-727	121	-139		
X	0.307	0.312		.312	.312				
Y	0.760	0.765				-312	.312		
Z	0.352	0.372		358	-361	760	762		
AA	0.470	0.530		- 500	500	362	.362		
AB	0.615	0.635		-626	627	-500	-500		
AC	0.053	0.033		-063	.063	.628	,630		
AD	0.240	0.260		247	.247	-063	.063		
AE	1.375	1.395		1.388	1.388	.250	1.390		
AF	0.115	0.135		-135	-135	-135			
AG	0.240	0.280		-133	-133		,135		
AH	0.240	0.260		247	251	.248	245		
AI	2.000	2.020	=======	-011		249	.254		
/ 1/		cept/Reje	ct		C'and	mester	2.000		
A 3		1:047		1 626		Transport of the Park			
	asured by			050.	0.030	udited by	:039	-	
IVIC	Date		1220		A	13.1724	06/01/0		

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	1





DART AEROSPACE LTD	Work Order:	24433
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. D		Page 1 of 1

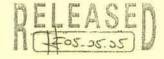
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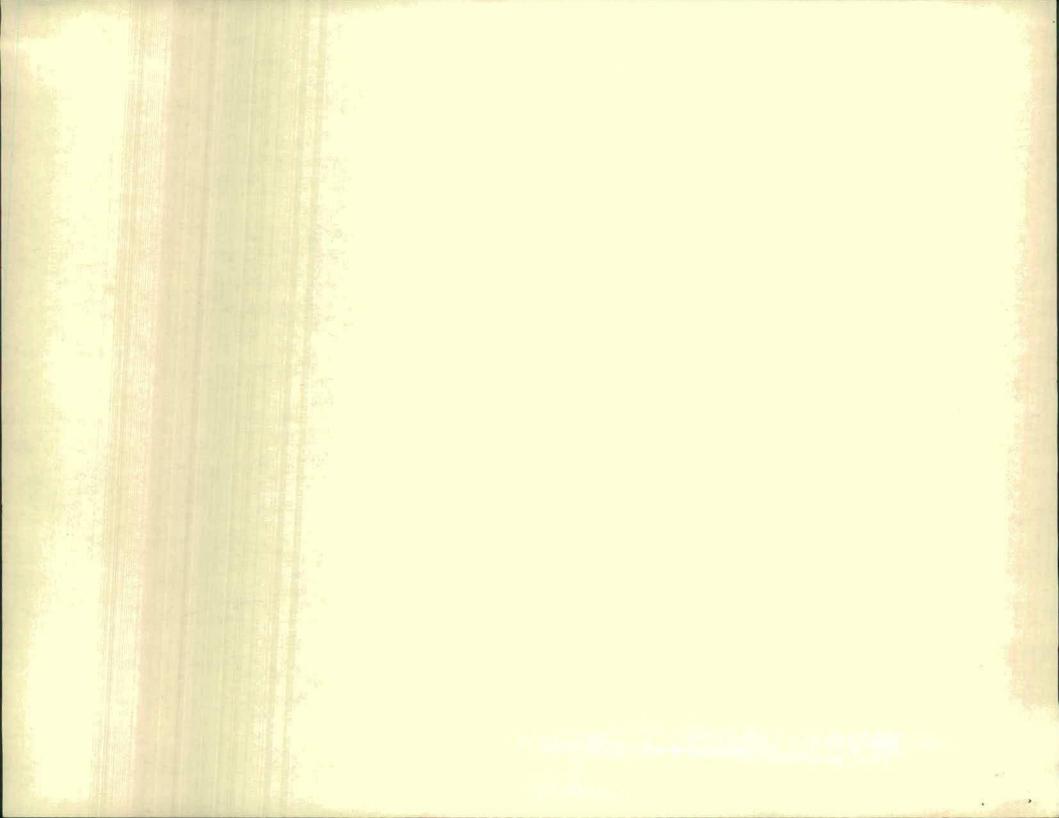
				Re	corded Acti	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682			~			
В	1.745	1.755		1.751	1.752	1.751	1.752		
С	3.495	3.505		3.502	3.502	3.500	3-500		
D	1.745	1.755		1.751	1.751	1.151	1,750		
E	7.990	8.010		0000	8.001	8.002	8.005		
F	0.490	0.510		.505	.506	,500	-501		
G	0.257	0.262	DT8683			V	-		
Н	0.375	0.380	DT8684	V	V	V	~		
1	0.490	0.510		503	. 500	-500	500		
J	1.174	1.184		1.178	1.178	1.150	1.179		
K	0.558	0.578		,572	.571	.572	.572		
L	1.174	1.184		1178	1.173	1150	1.179		
M	1.490	1.500		1.494	1.495	1-495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
0	3.869	3.879		118.8	3.870	3.500	3.800		
P	0.115	0.135		128	.127	128	128		
Q	0.115	0.135		-134	.135	1135	. 138		
R	0.240	0.260		,254	-254	.255	. 25+		
S	0.115	0.135		.125	-152	1127	. 126		
T	0.178	0.198		881	188.	.180	381,		
U	2.940	2,980		2.961	2.962	2.962	2.965		
V	0.230	0.250		240	. 240	. 240	645		
W	0.115	0.135		-126	125	. 127	. 127		
X	0.307	0.312		-311	116,	118.	.311		
Y	0.760	0.765		762	ニュア・	.762	.762		
Z	0.352	0.372		-363	.363	.363	364		
AA	0.470	0.530		,500	.500	·scc	,500		
AB	0.615	0.635		631	(627	.628	.628		
AC	0.053	0.073		· O(63	.065	.063	.063		
AD	0.240	0.260		249	,249	255	.256		
AE	1.375	1.395		1.388	1.388	1.387	1.388		
AF	0.115	0.135		132	.129	129	.129		
AG	0.240	0.280		248	.245	: 247	. 246		
AH	0.240	0.260		.251	, 250	. 250	. 250		
Al	2.000	2.020		2.002	2.001	2.000			
	Acc	cept/Reje	ct	111					
Aā		1:023		1.A/A	,030	.030	(503)		
	asured b					udited by	cn		
	Dat	01	10.1.			Date	11 /	the state of the s	

Measured by: Ms
Date: O(a/01/03

Rev Date Change Audited by Change Change Revised by Approved

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	- ' '
В	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	1





## Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Oct 05, 2005 10:49 am

Work Order No	: 0024433S
Project Name	: D2572

Project For :

Work Order Type : Main Main WO Number :

House Part Number : D2572

Amount Req'd: 8
Amount Done: 0
Start Date: 10-05-05

Est Finish Date : Act Finish Date : Drawings Reqd : No

Ok for Approval : Approval Rec'd :

Department Code:

Order Entry No : OE Value : 0.00

Est Mark Up : 0.000% Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
			========	======		
Burden	:	0.00	0.00	0.00		
			========	======		
Total Cost	:	0.00	0.00	0.00		
Mark up	:	0.000	0.000			
Selling Cost	:	0.00	0.00			

		Estimated	Actual
Labour Hrs/Amount Done	1	0.00	0.00
Profits/(Loss)		0.00	0.00

## Job Costing Report

	con concurrypor		Commence of the commence of th
Dart Aerospace Ltd.			Oct 05, 2005
Date Relopace Lea.			
Hawkesbury		-	10:49 am
Hawkesbary			AMERICAN AND AND AND AND AND AND AND AND AND A

distribution to the

Work Order No :	0024433	A	
Project Name :		Department Code:	
Project For :		Burden Flags :	
Work Order Type :	Main	WO Status :	
Main WO Number :		Invoice State :	Not Invoiced
House Part Number :	D2571	Invoice Date :	
Description : Sado	dle, Fwd, Out	Invoice Number :	
Manufactured : Yes		Invoice Amount :	0.00
Amount Reg'd :	8		
Amount Done :	0	Order Entry No :	
Start Date :	10-05-05	OE Value :	0.00
Est Finish Date :	11-10-05		
Act Finish Date :		Est Mark Up :	0.000%
Drawings Reqd :	No	Actual Mark Up :	0.000%
Ok for Approval :			
Approval Rec'd :		\$0 Posted to Fin	ished Goods

<sup>577</sup> = 1 × =	Estimated	Actual	Var. %	Posted To	Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
	========	========	======		
Burden :	0.00	0.00	0.00		
	========	========	======		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000		1148	
Selling Cost :	0.00	0.00		N. Francisco	

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

